

**Amendments to the Claims**

The current listing of the claims replaces all previous amendments and listings of the claims.

1. (Currently Amended) A method of manufacturing a ~~foam-molded~~ product, comprising ~~the steps of~~:

filling a resin containing a foaming agent into a mold cavity by injection within a time period from a time point just before completion of mold clamping to a time point after the completion of mold clamping;

allowing the ~~resin thus~~ resin filled in the mold cavity to form a skin layer over a surface ~~thereof of the resin~~;

~~thereafter~~ retracting a movable mold to ~~define~~ provide a predetermined cavity clearance between the movable mold and a stationary mold, ~~so as to cause the foaming agent contained in an uncured portion of the resin to foam; and~~

cooling the resin filled in the mold cavity to form a foam-molded product having a ~~surface forming a tight skin layer~~ surface and an inside portion in a foamed state.

2. (Currently Amended) The method according to claim 1, wherein ~~the~~ an amount of the resin to be filled into the mold cavity at the time point just before the completion of the mold clamping is between 50% ~~to~~ and 80% of the total amount of the resin to be filled in the mold cavity.

3. (Currently Amended) The method according to claim 1 or 2, wherein the filling of the resin at the time point just before the completion of the mold clamping starts within a time period ~~from a time point~~ between five seconds before the completion of the mold clamping ~~to a time point at which~~ and the completion of the mold clamping is ~~completed~~.

4. (Currently Amended) The method according to ~~any one of claims claim 1 to 3 or~~ 2, wherein the resin is injected into the mold cavity at an injection speed of between 5 ~~to~~ and

20 cm/sec.

5. (Currently Amended) The method according to ~~any one of claims claim 1 to 4 or~~ 2, wherein a time period from ~~the~~ starting of the filling of the resin into the mold cavity until the foaming agent contained in an inner portion of the resin filled in the mold cavity starts foaming is between 3 to and 10 seconds.

6. (Currently Amended) The method according to ~~any one of claims claim 1 to 5 or~~ 2, wherein a mold clamping pressure ~~at the step of~~ during the filling the resin into the mold cavity is ~~adjusted to fall within a range~~ between 20 kg/cm<sup>2</sup> and 100 kg/cm<sup>2</sup>, ~~while and~~ and a mold clamping pressure ~~at the step of forming~~ during the allowing the resin to form the skin layer is ~~adjusted to fall within a range~~ between 20 kg/cm<sup>2</sup> and 80 kg/cm<sup>2</sup>, ~~provided the mold clamping pressure at the step of filling the resin into the mold cavity is substantially equal to or higher than the mold clamping pressure at the step of forming the skin layer.~~